

(1)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 173608



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-4		SLY
110	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2		Shu
120	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC9		CPC
130	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1	DAS 24	BEB 18-07-02
150	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC7-2	9-89	CC 18-7-17
180	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2		CPC
190	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC10		CPC
200	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		CPC
210	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1		SA 18-07-18
220	Powdercoat	10 pcs	7/19/18	7/19/18	0.00	2.98	Powdercoat1		BL 18-7-18
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.87	HandFinish3		3EB 18-07-19
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		18-07-20
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		7/20/18
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		SMB
265	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		JUL 23 2018
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		DAS SMB
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 1134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 3:00 OVEN TEMPERATURE: 300° FINISH TIME: 4:20

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

5084313x10xRH

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	S077589
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	S070426
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	S081397
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	S084685 (W) 5092493
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	S077935
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	S079116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	12 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	41	0
	D3219-1	20	55	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	22	0
	D3066-1	20	10	0
	MS20600-AD4W4	160	1,681	0
250-Packaging	AN3-35A	20	312	0
	AN4-13A	80	941	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	214	0
	D2856-400	12	72	0
	D3235-1	20	6	0
	D3278-041	10	7	0
	MS21042L3	20	3,284	0
	MS21042L4	80	3,884	0
	MS21042L5	20	849	0
	NAS1149D0363J	40	3,378	0
	NAS1149D0463J	160	5,081	0
	NAS1149D0563J	40	1,290	0

Part Specifications

Specifications could not be found.

1 # 4093

Plex 3/5/18 4:03 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

11-750

Container No: S084313



Part: D350-591-312

Job No: 173608

Serial No/Batch: S084313

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/26/18



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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-4		JUL 12 2018
110	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2		
120	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC9		CPC
130	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		
140	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1	DAS	BEB 18-07-02
150	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC7-2	24	
180	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2	9-89	
190	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC10		
200	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		
210	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1		
220	Powdercoat	10 pcs	7/19/18	7/19/18	0.00	2.98	Powdercoat1		
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.87	HandFinish3		
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		11/2/2018
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		
265	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

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180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

4356

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	507750
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	507750
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	507750
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5084685 (ea)
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5067892
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5068656
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	5082275
D2856-400-120	Abrasion Strip 4" Wide (Per Foot)	20 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5015269
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	5062379
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	5068062

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	41	0
	D3219-1	20	55	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	22	0
	D3066-1	20	10	0
	MS20600-AD4W4	160	1,681	0
250-Packaging	AN3-35A	20	312	0
	AN4-13A	80	941	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	214	0
	D2856-400	12	72	0
	D3235-1	20	6	0
	D3278-041	10	7	0
	MS21042L3	20	3,284	0
	MS21042L4	80	3,884	0
	MS21042L5	20	849	0
	NAS1149D0363J	40	3,378	0
	NAS1149D0463J	160	5,081	0
	NAS1149D0563J	40	1,290	0

Part Specifications

Specifications could not be found.



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004356	S091280	AN3-35A	Bolt	s067891	ST348	20
004356	S091281	AN4-13A	Bolt	s067892	ST344	80
004356	S091282	AN5-36A	Bolt	s068656	ST336	20
004356	S092864	D2230-3	Mounting Lug	s088979	ST521	40
004356	S091279	D2618	Bushing	s082275	ST008	20
004356	S092720	D2856-400-720	Abrasion Strip 4" X 7.20"	S092667	ST418	20
004356	S091222	D3235-1	Mounting Lug	S069956	ST522	20
004356	S083384	D3278-041	Support Assembly	S083584	ST522	7
004356	S092779	D3278-041	Support Assembly	s092071	ST522	3
004356	S091250	MS21042L3	Nut	s078167	Cycle Retire	20
004356	S091236	MS21042L4	Nut	s062378	ST303	80
004356	S091235	MS21042L5	Nut	s058178	ST303	20
004356	S091239	NAS1149D0363J	Washer	s015269	ST263	40
004356	S091238	NAS1149D0463J	Washer	s062379	ST263	160
004356	S091237	NAS1149D0563J	Washer	s068662	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/17/18 3:00 PM dart.quirion.sonia

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY